

Work Order ID 143438

Tuesday, March 15, 2016 11:48:32 AM

143438

Page 1

Item ID: D500-560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Mirror Installation 6"
 Start Date: 3/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAR 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D500-560-041 CHG006								
110	Small Fab	0.00							
110	Small Fab	0.02							
Small Fab	Memo								
	Before assembly repass tap on stud.								
	Assemble as per drawing D500-560								
	PAGE 8- BLUE FILE								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC	0.00							
Quality Control	Memo								

DAS
21
9-89
16-07-18

4X
DAS
27
9-89

Pick Kit

DAS
6
9-89

JUL 18 2016

JUL 25 2016

4X

16-07-18

DAS
36
9-89

(4)

DAS
38
9-89
JUL 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

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NR2

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130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

4 DAS 6 9-89 JUL 25 2016 PC

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

4 DAS 27 9-89

JUL 25 2016

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D500-560-041
LOCATION: FG0111x sold
3x fg011

4 DAS 27 9-89 JUL 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 143438

Tuesday, March 15, 2016 11:48:32 AM

143438

Page 3

Item ID: D500-560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Installation 6"

Start Date: 3/31/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
Qty
21
9-89Reject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

JUL 25 2016

Quality Control

SA 7/25/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Tuesday, March 15, 2016 11:48:32 AM

Page 1

Work Order ID: 143438

143438

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation 6"

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G
10.04.22 chg route seq DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R10		Purchased	No			110	Each	58.0000	4	16			DAS 6 9-89
AN526C1032R10													
Screw													

Location	Loc Qty	Loc Code
ST328	58	
m133234	58	

D1048		Manufactured	No			110	Each	1.0000	2	8			DAS 6 9-89
D1048													
Clamp													

Location	Loc Qty	Loc Code
GA	1	
132154	1	

D1049		Manufactured	No			110	Each	10.0000	2	8			DAS 6 9-89
D1049													
Saddle													

Location	Loc Qty	Loc Code
GA	10	
141415	10	

D2010-101		Manufactured	No			110	Each	1.0000	1	4			DAS 6 9-89
D2010-101													
Mirror Bracket 369/500													

Location	Loc Qty	Loc Code
ST479	1	
117229	1	

JUL 18 2016

DQA: _____ Date: _____



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Picklist Print

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Page 2

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D500-560-041

Parent Item Name: Cargo Mirror Installation 6"

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 4.00

Required Qty: 4.00

D2010-103 Manufactured No

110 Each 9.0000 1 4

D2010-103

Mirror Arm 369/500

**

Location

Loc Qty

Loc Code

ST351

9

137132

3

139134

6

D2011-101 Manufactured No

110 Each 19.0000 1 4

D2011-101

Mirror 6"

**

Location

Loc Qty

Loc Code

FG

2

106348

2

ST384

17

140542

6

141126

11

AN3-4A Purchased No

140 Each 117.0000 4 16

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

117

m133990

117

DAS
27
9-89

JUL 18 2016

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Shop Packet Print

Page 2

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OTHER : ☐					

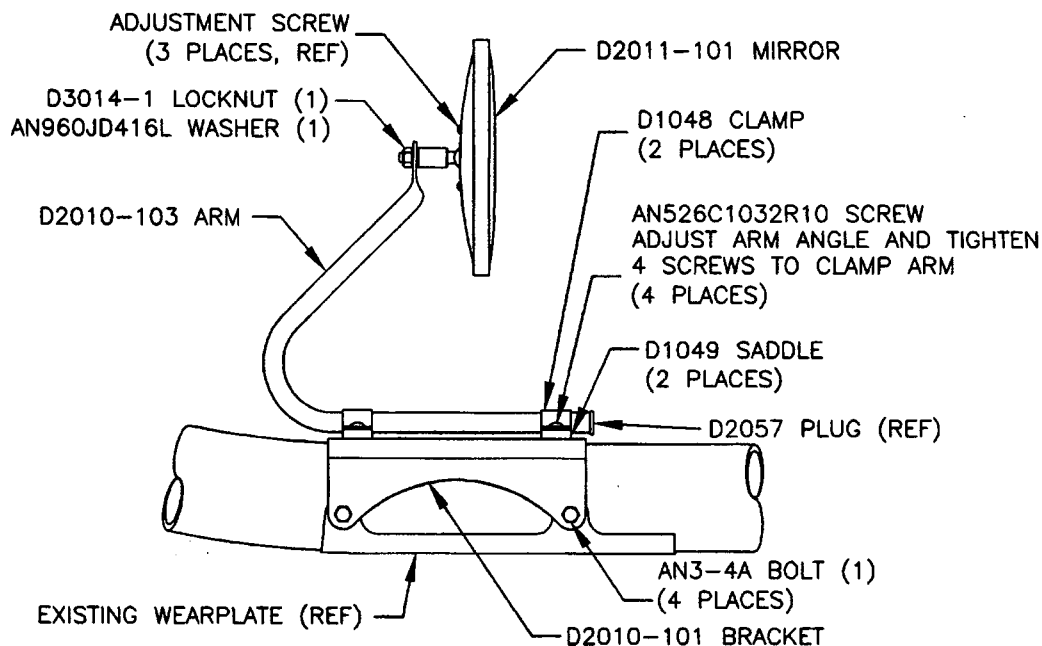


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041	1.0 lb	-45 in	-45 lb-kG	24 in	24 in-lb
Cargo Mirror Assembly	0.45 kg	-1.14 m	-0.51 m-kG	0.61 m	0.27 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR